Work Ord Monday, Noven				*762	215*	*						Page 1
Item ID: Revision ID: Item Name:	D3403-3 Bushing			Accept	*N90		010	N *	Setup	Start	I VI	S1* S2*
Start Date: Required Date	11/7/2011 : 11/16/2011	Start Qty: 60.00 Req'd Qty: 60.00	*60* *60*		Cust Ite Custom							
Reference:		1/	1/ // 1/ -						Run	Start	* *	D1*
Approvals:	Process Pla	· · · · · · · · · · · · · · · · · · ·	Date:	Tooling: _ SPC (Y/N):		Date:				Stop	ν Ν*	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool I	D Tool	# Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr						1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1				
D3403	D											4
*100 *100*		Hardinge CNC LATHE	SMALL	0.00				60	()	ong.	SI wull
Hardinge Hardinge CNC Lath	he Small	Mem o 1- Turn as Folio Ro 2-Deburr	per Folio FA558 & Dwg.D3- ev: Dwg Rev: D	0.00 403						_		
*110 *110*		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				60	(2	and a]]]][
QC Quality Control		Memo		0.00								
120		QC8- Inspect parts - sec	ond check	0.00			11/8		C	$\langle \rangle$		
120 QC Quality Control		Memo		0.00	D	(1)	11/18	<u>ن</u>	<u> </u>			

Dart Aerospace L	Lta
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W/O:			WC	RK ORDER CHANG	ES				-
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-				, .					
	-								
Part No	<u>. </u>	PAR #:	Fault Cated	lorv:	NCR: Yes	No DQ	Δ:	Date:	<u> </u>
		esolution:							
NCR:		1	WORK ORDE	R NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	ion C	Chief Eng	QC Inspector
				,					
								į	

Work Orde Monday, Novem				*762	215*				Page 2
Item ID: Revision ID:	D3403-3			Accept	*N9000	140100)* s	etup Start	*NS1*
Item Name:	Bushing							Stop	*NS2*
Start Date: Required Date: Reference:	11/7/2011 11/16/2011	Start Qty: 60.00 Req'd Qty: 60.00		Λ* · Λ *	Cust Item ID Customer:	:			
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):	Date		R	un Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 130 *120* Packaging Packaging)	Operation Description Identify as per dwg & Sto	ock Location:	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accept Qty	Qty N	Reject Insp. Number Stamp
140 *140 * QC Quality Control		QC21- Final Inspection -	l Work Order Relea	o.00				N	111/21/

Q(V) (4)

	D	ar	t /	Ą	eı	O,	s	q	a	C	е	L	tc	
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W/O:			W	ORK ORDER CHANG	ES				6
DATE	STEP	PRO	CEDURE CHA	INGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	4 :	Date:	
		solution:							
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	₹)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign o	& Section		Chief Eng	QC Inspector
, <u>, , , , , , , , , , , , , , , , , , </u>		, <u>, , , , , , , , , , , , , , , , , , </u>		·					
	:								
	1		i		i	- 1			

Picklist Print

Monday, November 07, 2011 2:42:42 PM

Work Order ID: 76215

76215

Parent Item:

D3403-3

D3403-3

Parent Item Name: Bushing

Start Date: 11/7/2011

Required Date: 11/16/2011

Page 1

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP Rev:A05.08.31New issueKJ/JLM

IPP Rev:B 06-03-07 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	127.6570	0.206	13.01053		0	7/ 1/
M303R0	750								**	12.000	<u>'</u>	1	11/11/17

303 Round Bar 0.750

Loc	ation	Loc Oty	Loc Code	
' MA	Т028	127.657		
	117328	29.533		
	117798	4.004		
	118509	9.809		<u> </u>
12'	C 119346	84.311		12.000

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	ES				*
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				w.					
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No DQ	A :	Date: _	
_	Re	esolution:	Disposition);	_ QA: N/C	Closed:		Date: _	
NCR:		,	WORK ORDE	ER NON-CONFORMA	ANCE (NO	CR)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Da		ion C	Chief Eng	QC Inspector
		•							
								1	

DART AEROSPACE	LTD	 Work Order:	76215
Description: Bushin	15	Part Number:	D 340 3-3
Inspection Dwg:	Rev:		Page 1 of 1

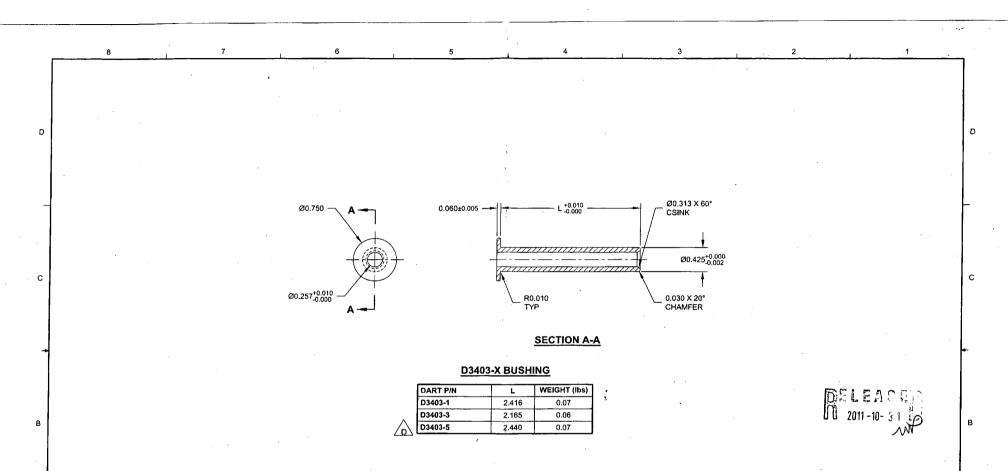
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.165	t.010/-0.00	2.1685	✓		5108	
0.060	+1-0.005	0.0595	/		, , t t	
\$ 0.257	+0.010/-0.0	\$0.25			n	
\$ 0.750	+1-0.010	\$0.7495			L į	
\$0.425	+0.0001-0.002	60.424			βl	
0.030 X 20°	+1-0.010	0.030x20°	1		الر	
\$ 0.313 X 60°		\$0.315 x 40°			N	
					•	
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						, <u></u>
						······································
			<u> </u>			

Measured by:	Stong	Audited by:	5	Preliminary Approval:	·
Date:	11/11/17	Date:	WALK	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



SHOP COPY

RED RN 1 1

ENGINDERING

UNCONTROLEMANTY

SUBJECT TO AMENDAPINE

WITHOUT NO. 8%

REFORMAT TO CURRENT STD PER QSI 043; ADDED 10.04.21 D3403-5. TOL WAS +0.005/-0.000. REASON: PAR#10-029 06.01.23 ADD COUNTERSINK PH A NEW ISSUE PH 05.03.07 REV. DESCRIPTION BY DATE DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA XDF

DESIGN DRAWN CHECKED REV. D DRAWING NO. MFG. APPR. D3403 SHEET 1 OF 1 APPROVED SCALE TITLE BUSHING DE APPR. COPYRIGHT @ 2005 BY DART AEROSPACE LTD 11.10.28

2) FINISH: NONE

NOTES:

1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582

REF, DART SPEC. M303R

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: PER TABLE

FOR -5, 2.440 WAS 2.500 (PER PAR 11-125)

11.10.28

Da	ar	t A	\ei	ro:	sp	ac	e	Ltc	
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W/O:			V	VORK ORDER CHAN	GES					
DATE	STEP	PROCEDURE CHANGE				у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		*								
		PAR #:	Fault Category: N			CR: Yes No DQA: Date:				
		esolution:								
NCR:		V	VORK OR	DER NON-CONFORM	ANCE ((CR)				
DATE	STEP	Description of NC	Corrective Action Section				Verification		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng) . S	ign & Date	Section C	n C	Chief Eng	QC Inspector
•										
	**									
					}					